

Hämeenkatu 9
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- The concrete base must be sufficiently moist to prevent water in the product from being absorbed into the base too quickly.
- Additional liquid adhesion promoters should not be used.

Mixing and application

- The workspace must be protected from strong wind, sunlight and rain.
- During casting and product hardening, the temperature should be +5°C...+25°C.
- The product is mixed into a smooth mass with a pipe or paddle mixer. When using a paddle mixer, the mixing time is 1 to 3 minutes. When mixing with a mortar mixer or concrete mixer, the mixing time is approximately 5 minutes.
- The amount of water must be in accordance with the instructions on the product card. Deviating from the recommended amount of water weakens the product's strength values, increases the risk of separation and affects the development of strength and reduces workability.
- The working time is roughly 1 hour from the mixing.
- The product can be applied by pumping or manually onto the base. The casting must be carried out as soon as possible after mixing of the mass, thus making full use of the swelling of the fresh mass. The mass is pliable and no sealing is required. If necessary, casting flow can be enhanced by ramming or vibrating very lightly. When making thick casting layers (more than 100 mm), it is advisable to cast with several layers. Each layer must be allowed to harden for at least 24 hours before the next casting.
- The casting mould must be tight, since soldering concrete is very pliable and highly mobile. Normal castings can be done from one side. Build the mould for this side higher and wider so that the soldering concrete can fill the casting space under its own weight.
- Wash the tools with water immediately after the work has been completed.

Aftercare

- Sufficient moisture of the installed product must be ensured during the curing phase so that the curing reaction works correctly and the desired strength is achieved.
- The surface of the installed product must be kept moist for 7 days. Depending on the conditions and work site, moistening can be done either with water spray, plastic film, or with Fescon aftercare material.
- Especially in the spring, aftercare should be started immediately and carried out carefully, since in the spring the relative humidity of the air is often less than 40% RH. Low relative humidity combined with sunlight and wind dries the surface very quickly.

Other considerations

- In anchoring solder castings, the drill hole must be 40 mm larger than the piece to be fixed.

Waste handling

Storage and handling of waste

See the separate storage and disposal instructions <https://www.fescon.fi/en/material-bank>

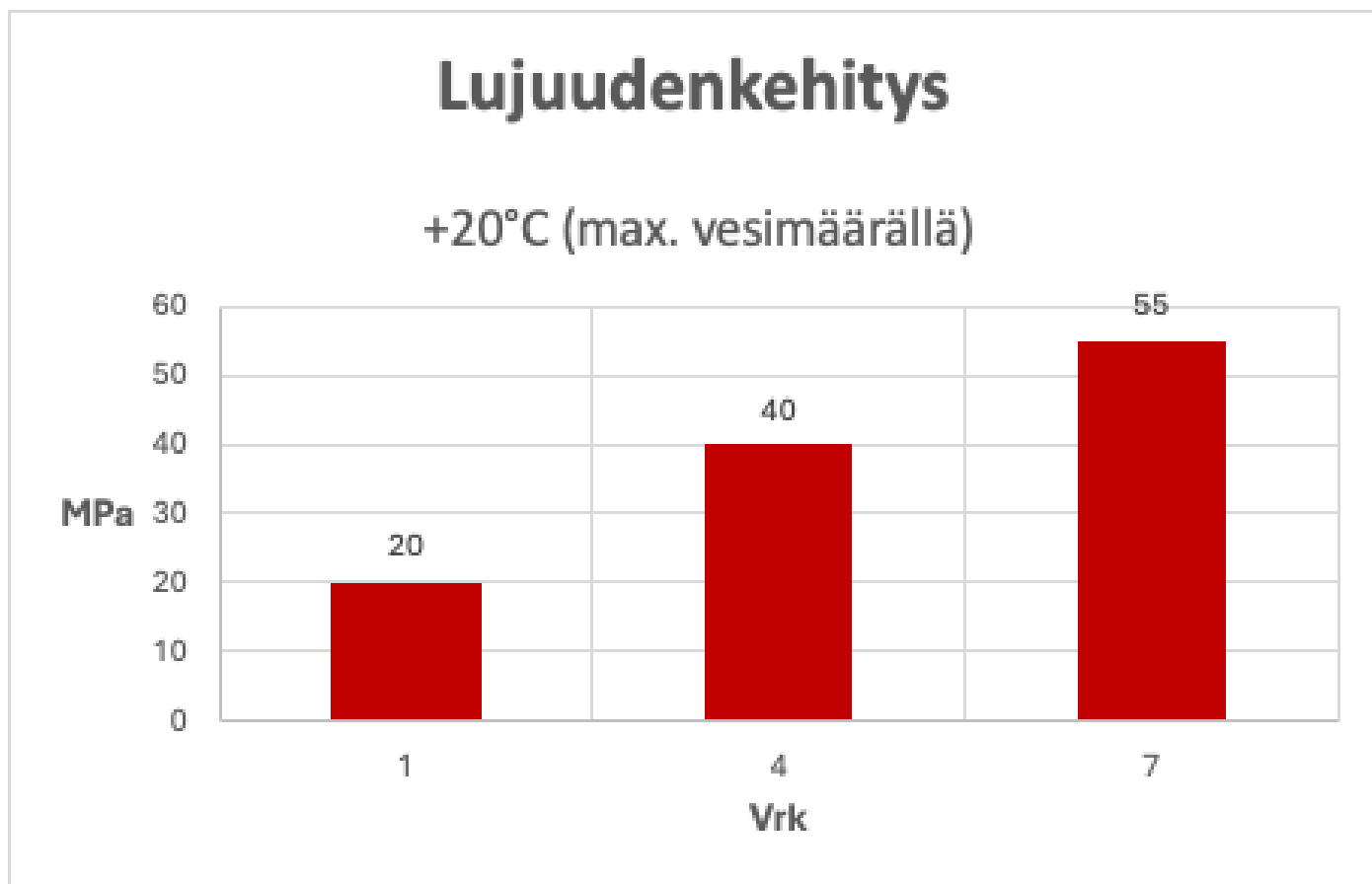
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Technical information

Material usage	Approx 2.0 kg/m ² /mm
Water requirement	2.3 – 2.4 l / 25 kg
Finished compound	Approx. 500 l / 1000 kg
Type	Powder
Binder	Sulphate resistant cement
Colour	Grey
Maximum grain size	4 mm
Package size	1000 kg
Storage	Storage time in a dry location approx. 1 year
Density	Approx. 2100 kg / m ³
Layer thickness	30 – 100 mm
Fibre	Not fiber reinforced
Additives	Additives to improve weather resistance, pumpability and workability
Usage temperature	+5°C...+25°C
Workability time	Approx. 1 h
Walkable	Approx. 8 h
Strength class	C60/75 (R4, EN 1504-3)
Adhesion strength	> 1,5 MPa (R4, EN 1504-3)
Reaction to fire	A1
Exposure class	XC4, XS3, XD3, XA3, XF4 (50 v), XC4, XS3, XD3, XA3 (100 years)
Frost resistance	Frost-resistant, for indoor and outdoor use
Waterproofness	Water-resistant

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